

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83937

83937

Page 2

April-27-12 2:52:29 PM

Item ID: D3205-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pedal Bracket
 Start Date: 27/04/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 11/05/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	QC8- Inspect parts - second check	0.00				8	4		
-----	-----------------------------------	------	--	--	--	---	---	--	--

130

QC Memo

Quality Control

140	Chemical Conversion Coat per QSI005 4.1	0.00				8	76	12516	
-----	---	------	--	--	--	---	----	-------	--

140

HandFinish Memo

Hand Finishing

150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				8X			MT
-----	--	------	--	--	--	----	--	--	----

150

Powdercoat Memo

Powder Coating

Note: Cover the thread hole for D3205-1 before powder coat.START
 TIME: 11:05 OVEN TEMPERATURE:

FINISH TIME:

32:00F

11:30

M117338

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Picklist Print

April-27-12 2:52:32 PM

Page 1

Work Order ID: 83937

83937

Parent Item: D3205-1

D3205-1

Parent Item Name: Pedal Bracket

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP A04.06.09New issueKJ/RF

IPP Rev:B 08-12-16 attach DEO DD verified by:EC

IPP

REV:C AS PER REV B 12-03-23 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B2.500X03.2 5		Purchased		No		100	f	7.5720	0.3646	3.070316			

M7075T73B2 500X03 25

7075-T73 Bar 2.50 x 3.25

**

85 12-05-13

Location

MAT008

116680

119916

Loc Qty

7.572

1.572

6

Loc Code

3.070316

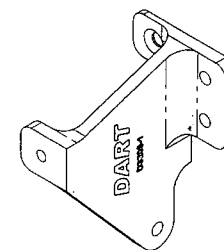
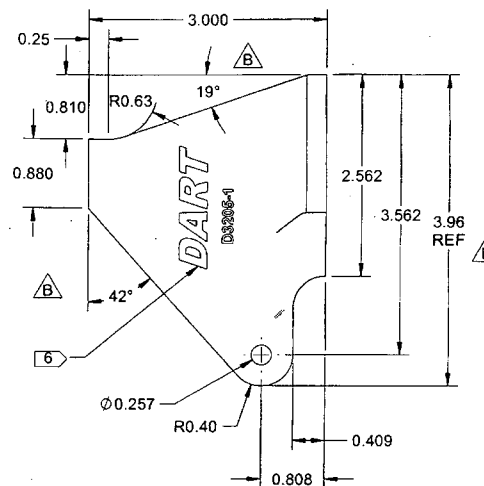
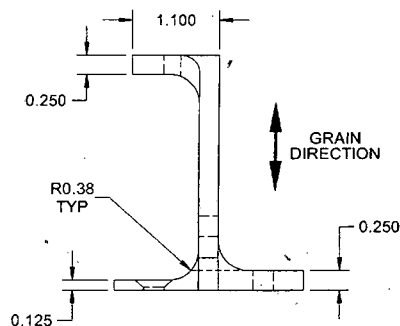
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83937 M

12/04/27

RELEASED
2012-03-21
ECN 12-545 4P

NOTES:

- NOTES
- 1) MATERIAL: 7075-T73 ALUMINUM BAR
PER QQ-A-200/11 OR QQ-A-250/12
REF DART SPEC M7075T73B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3
 - 7) WEIGHT: 0.28 lbs

B	CONVERT DRAWING TO STANDARD FORMAT; 3.96 WAS 3.99 (ZN C2-1); 19" WAS 18" (D3-1); 42" WAS 41" (ZN C4-1); CHANGE DIMENSIONS TO 2 DEC. PL (ZN D5-1, D6-1, C4-2, D5-2, C7-2); ADD CHAMFER (ZN D3-2); REMOVE ENGRAVING ON D3205-3		RF	12.02.24
A	NEW ISSUE		RF	04.01.27
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	<i>[Signature]</i>		DRAWING NO.	REV.
MFG. APPR.	<i>[Signature]</i>		D3205	SHEET 1 OF
APPROVED	<i>[Signature]</i>		TITLE	SCAL
DE APPR.	<i>[Signature]</i>	BRACKET	NT	
DATE	12.02.24		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT	

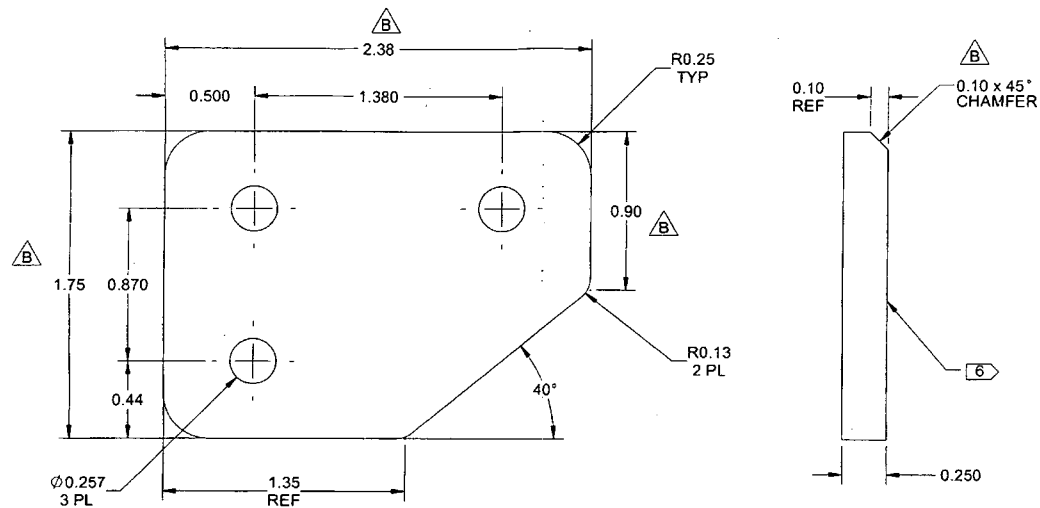
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D3205-3 BACK PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs

RELEASED
2012-03-21
ECN 12-545 4P

DESIGN	RF	DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3205	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	12.02.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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DART AEROSPACE LTD		Work Order:	83937
Description: Pedal Bracket		Part Number:	D3205-1
Inspection Dwg: D3205	Rev: <i>RBA</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.096	✓		vern	RT-4
0.250	+/-0.010	.252	✓		"	
R0.37	+/-0.030	.37	✓		rad gauge	
0.125	+/-0.010	.125	✓		vern	RT-4
0.250	+/-0.010	.250	✓		"	
2.380	+/-0.010	2.374	✓		"	
1.380	+/-0.005 +/-0.010	1.378	✓		"	
0.500	+/-0.005 +/-0.010	.495	✓		"	
0.880	+/-0.010	.880	✓		"	
Ø0.470 x 100°	+0.005/-0.000	.475	✓		"	
0.440	+/-0.005 +/-0.010	.439	✓		"	
0.600	+/-0.005 +/-0.010	.595	✓		"	
5/16-28UNF-313	N/A					
0.250	+/-0.010	.240	✓		"	
Ø0.257	+0.005/-0.000	.258	✓		"	
1.750	+/-0.010	1.750	✓		"	
0.870	+/-0.005 +/-0.010	.869	✓		"	
0.440	+/-0.005 +/-0.010	.439	✓		"	
R0.25	+/-0.030	.250	✓		rad gauge	

Measured by: <i>RT/ST</i>	Audited by: <i>R</i>	Prototype Approval:	N/A
Date: 12-05-14	Date: 12-5-15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM <i>ST</i>	<i>ST</i>

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